

Work Order ID 51431

August 24, 2009 1:00:26 PM



Page 1

Item ID: D2013-6

Accept



Setup Start



Revision ID: C

Stop



Item Name: Mirror Bracket RH, 204

Start Date: 8/25/09 Start Qty: 5.00



Cust Item ID:

Required Date: 8/25/09 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2013

Rev C

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Punch as per template D2013-T5 and Dwg D2013
2-Flatten ends of D2013-6 tube as per Dwg D2013 using DT8545 3-Bend tube
as per Dwg D2013 using Jig DT8201
Identify as D2013-6.
4-Deburr as required

SB 09/08/25

7m.h 09/08/25 (5X)

S /

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) S 09/08/25

(4) /

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51431

August 24, 2009 1:00:26 PM

Page 2

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Date:

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Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

Identify as per dwg & Stock Location: **WADZSA**

0.00



Packaging

Memo

0.00

Packaging

Cpl 09 08 25

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/25

RL 09-8-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

August 24, 2009 1:00:25 PM

Page 1

Work Order ID: 51431

Parent Item: D2013-6RevC

Parent Item Name: Mirror Bracket RH, 204

Start Date: 8/25/09

Required Date: 8/25/09

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	262.0510	9.1053			



304 RD Tube .750 x .049W



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	262.0510026	
107518	7.27	
108498	0	
109314	8.5	
110113	0.73	
110271	0.03	
111096	9	
111457	11.43	
111619	13.2700026	
112187	211.821	

10 88 09/08/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED OS	DRAWING NO. D2013	REV. C SHEET 1 OF 3
DATE 99.06.07	TITLE MIRROR BRACKET		SCALE NTS
A	90.10.22	NEW ISSUE	
B	94.06.15	REDRAWN	
C	99.06.07	REDRAWN, CHANGE OF DIMENSIONS	

Wb 51431

BEND PER JIG DT8201

R0.38 (REF)

8.50

38°

10.50

35°

1.50
(TYP)

D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)

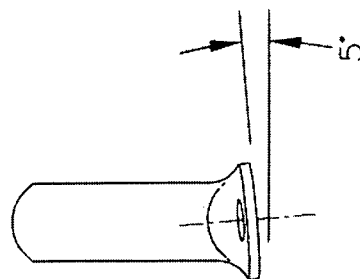
DRILL $\phi 0.257$ (TYP)

0.400 (TYP)

CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

RELEASED
KE 99.06.10



VIEW A-A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

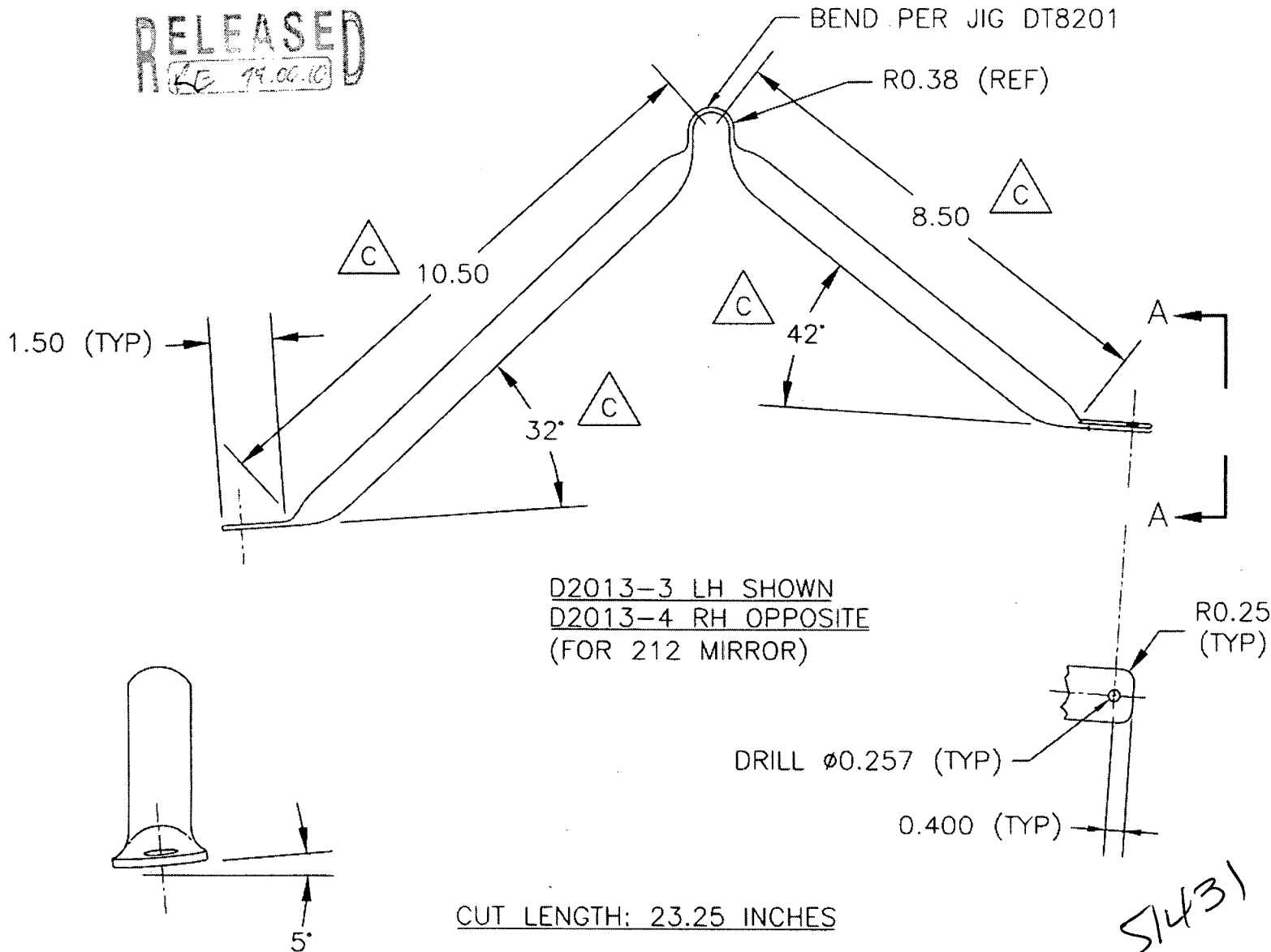
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
 LE 99.06.10

DART

QA COPY
 ISSUED



MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
 0.750 O.D. x 0.049 WALL

DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	[Signature]	
DATE	99.06.07	TITLE	D2013	REV. C
			MIRROR BRACKET	SHEET 2 OF 3
				SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

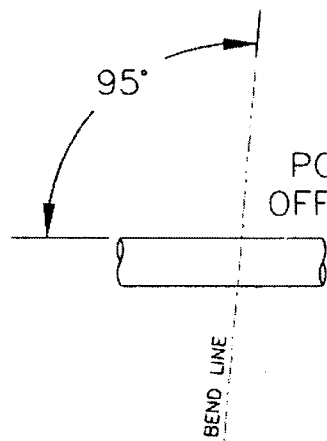
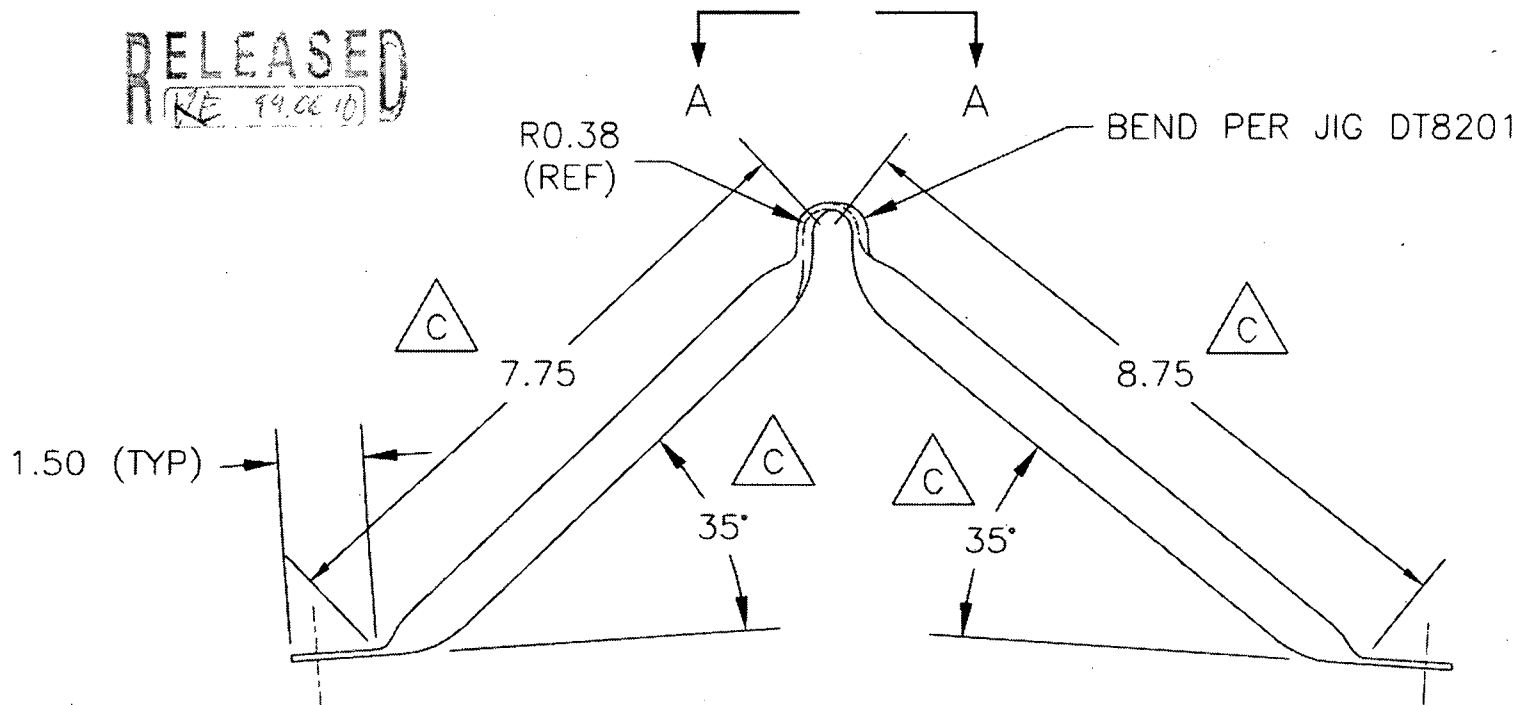
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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RELEASED
 RE 99.06.10

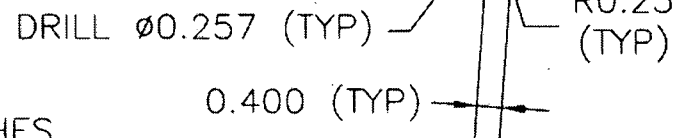


VIEW A-A

D2013-5 LH SHOWN
 D2013-6 RH OPPOSITE.
 (FOR 204 MIRROR)

CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
 0.750 O.D. x 0.049 WALL



DART

UNCOPYRIGHTED

DESIGN	JB	DRAWN BY	RE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	RE	APPROVED	RE	DRAWING NO. D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C
				SHEET 3 OF 3
				SCALE NTS